Work Order ID 85737

June-14-12 1:55:53 PM

Page 1

Item ID: D350-607-547 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Utility-Basket 14/06/2012 **Start Qty:** 1.00 **Start Date:** Cust Item ID: **Required Date:** 28/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: MLJ Date: $\frac{12}{06}/\frac{4}{14}$ Tooling: Approvals: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Reject Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Oty Number Stamp Draw Nbr **Revision Nbr** D350-607-3 Α 100 0.00 DOCUMENT CONTROL *100* DC Memo Document Control Photocopy bluefile & type labels per PPPD350-607-547 CHG 140 Pick Kit 0.00 *140* Packaging 0.00 Memo Packaging 150 QC4-100% Inspect kits for completeness 0.00 *150* QC Memo Quality Control

June-14-12 1:5.	5:53 PM	F1.E47.000.000		();)	/ .5 /						r age 2	
Item ID: Revision ID:	D350-607-54	17	: : :	Accept	*N9000	740100)*	Setup	Start	*N.	S 1*	
Item Name:	Heli-Utility-Ba	asket							Stop	*NS	S2*	
Start Date:	14/06/2012	Start Qty: 1.00	*1*		Cust Item ID):						
Required Date: Reference:	28/06/2012	Req'd Qty: 1.00	*1*		Customer:							
Approvals:		n:	Date:	Tooling:	Dat	e:	į		Start Stop	*NF	₹1*	
	QC:		Date:	SPC (Y/N):	Dat	e:			отор	*NF	₹2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	-
160		Packaging		0.00			1					
160 Packaging		Мето		0.00			- [X	-			- ST	
Packaging		Identify and Location:	O	PPP D350-607-547						(7-7-	-//
170		QC21- Final Inspection	- Work Order Release	0.00								
170								MO	ング	1210	7/11	
QC Quality Control		Memo		0.00					ML	J 12	4071	١

	4									DQA:	Dat	e:
NCR: Yes	/ No				WORK ORDER NON-	·CO	NFOR	MANCE / UPDAT	Έ			
										QA Closed:	Dat	e:
Work Order:	_				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. NCR No.				Rework Scrap Use-as-is Work Order Update	Machining Small Finish			rosstube mall Fab Finishing	Pro Rec/Sto	Engineering Quality		
					Work Order opuate			Large Fab Cor	mposite]	Other	
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance	1	Initial lief Eng	Action		Sign &		
Doc/Data		- 4	3.7		or Non comormance	10	ilei Elig	Description	<u>n</u>	Date	Verification	QC Inspector
Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized											**	
Landing G						AUL	T CATE					
	Bending Pace Process Crushed/Conspection Other Positioned Ripples on Forque Was Furning Seware/Twis	t Concent frimp at B Strip in T Wrong Inner Be aves in Ex quence	tric to C Bending Fube nd trusion		Hardware Breaking Missing Size/Length Spinning Threading Wrong Drill Holes Misaligned Ovar/Undersized		Finish Inspection Instruction Instruction Iigs/Fixtu	Short ntation/Data on Incomplete on Unqualified ons Incomplete/Unclear ures/Tooling rect		Maintenand Mislabeled Off-Set Orientation N Out of Calibra Out of Seque Outside Dime Over/Under t Part Lost Part Moved	Aisread ation ceensions	Set-up Supplier Temperature/Cure Weld Wrong Stock Pulled Other
H:/FORMS/Quality A				Rev F	Too Many	!	Kit Missii	ng		Raw Material		

Picklist Print

June-14-12 1:55:56 PM

Work Order ID: 85737

Parent Item: D350-607-547

Parent Item Name: Heli-Utility-Basket

Comments:

IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC

85737

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

	REV:B 12.03.06 A	AS PER ECN12-53	35 DD									
Component Item ID/ Item Name	Replacement Item ID		Bin	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-511 H76 *D350-607-601 Quick Release Basket Mou	7~511*	Manufactured	No		140	Each	3.0000	**	18	5742		1

IPP

						· minu	Qty Issued Issued
D350-607-511 HOW	Manufactured	No		140	Each	3.0000	
D350-607-511 Quick Release Basket Mounting Installation							** 857/2
			Location	Loc	<u>Oty</u>	Loc Code	
			PK13		3		
			85131 85132		1		
			85132 85133		1		
D2690-6	Manufactured	No		140	Each	12.0000	$\bigcap \bigwedge$
> *D269ñ-6*							** DEEXICO
Lanyard Assembly							685757 C
			Location	Loc	<u>Oty</u>	Loc Code	
			ST014		12		
D3912-041			83360		12		
	Manufactured	No		140	Each	0.0000	
√* D3912-041*							** 885752.
Eyebolt Receiver Assembly D4032-043	Manufacture 1	No		140	Б.		
1 +15 4000 040+	Manufactured	INU		140	Each	0.0000	
D4032-043 Short Basket Assembly, Light Lid (350)							** 85738 N
D4085-3	Manufactured	No		140	Each	6.0000	
C +57005 0+	wandiactured	7.10		140	Each	6.0000	** 50 1) 79
Placard, Instructions							" DAT- C
			Location	Loc	Otv	Loc Code	
						-Joe Coul	

Location		Loc Oty	Loc Code
ST092		6	
83657	.23	6	
,			

										DQA:	Dat	e: `		
NCR: Y	'es / No				WORK ORDER NON-	·CO	NFOR	MANCE / UPI	DATE		-			
		···							-	QA Closed:	Dat	e:		
Work Orde	er:				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				d. Eng. Coor. re/Packaging Supplier Other	Engineering Quality				
Root				Desci	ription of work order update	T	Initial	Acti	ion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	1	nief Eng			Date	Verification	QC Inspector		
Doc/Data						1		0 0007	·ption	Date	Vermeation	QC IIISPECTOI		
quip/Tooling		į												
Operator					171									
Viaterial														
Offset/Setup		ł												
Other														
rocess								,						
upplier											i	\$.		
raining														
Inauthorized														
					F	AUI	T CATE	GORY	V					
Landing	g Gear				Hardware			General						
_		Passes Be			Breaking		Burrs			Maintenand	ce [Set-up		
_	Centre N	ot Concer	ntric to (D/S	Missing		Contami	ination		Mislabeled		Supplier		
L	Cracks			L	Size/Length		Cut Too	Short		Off-Set	T	Temperature/Cure		
L	_	Crimp at	_	:	Spinning		Docume	ntation/Data		Orientation I	Misread	Weld		
-		n Strip in	Tube		Threading		Finish			Out of Calibr	ation	Wrong Stock Pulled		
-	Other			Inspection	on Incomplete		Out of Seque	nce						
-		ed Wrong			Drill Holes		Inspection	on Unqualified		Outside Dime	ensions	Other		
<u> </u>		n Inner Be		_	Misaligned		Instructi	ons incomplete/Ur	nclear	Over/Under t	tolerance			
_		Vaves in E	xtrusion	· _	Ovalized		Jigs/Fixtu	ures/Tooling		Part Lost				
_	Turning Sequence Over/Undersized				<u> </u>			Part Moved						
	Wave/Twist in Tube Too Many				Kit Missing			Raw Material						

Picklist Print

June-14-12 1:55:56 PM

Work Order ID: 85737

Parent Item:

D350-607-547

Parent Item Name: Heli-Utility-Basket

85737

Location

ST357

D350-607-547

120187

120422

120770

121652

122063

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00



AN4-13A
AN4-13A
Bolt

Purchased

No

140

Each

1,346.000

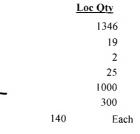
Loc Code





Purchased

No



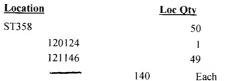
50.0000

Loc Code



, .		
AN310C4		
AN	194	 1
Nut	io I	 4

Purchased No

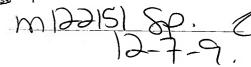


30.0000

Loc Code



**



Location Loc Oty ST344 30 120360 5 121166 3 121444 22 June-14-12 1:55:56 PM

Work Order ID: 85737

D350-607-547

Parent Item Name: Heli-Utility-Basket

Parent Item:

MS17984-C413

Purchased

Purchased

Purchased

85737

No

No

No

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

Required Qty: 1.00

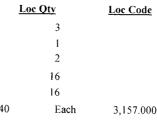
Start Qty: 1.00

**

19.0000

Locatio	<u>n</u>	Loc	Oty	
ST315			3	
	.114340		1	
	118612		2	
ST333			16	
	121350		16	
	ter	140	Each	

140



Each



Location	<u>Lo</u>	c Oty	Loc Code
ST300		3157	
119075		116	
121011		232	
121444			
121652		300	
	140	Each	191.0000



MS24665 <u>-15</u> 1		
M\\$24	1665-151	
Cotter Pin		

Location Loc Qty Loc Code ST309 191 17566 191

Picklist Print

June-14-12 1:55:56 PM

Work Order ID: 85737

Parent Item:

D350-607-547

Parent Item Name: Heli-Utility-Basket

85737 *D350-607-547*

Start Date: 14/06/2012

Required Date: 28/06/2012

Required Qty: 1.00

Start Qty: 1.00

Purchased

No

No

No

Location

115358

117735

119097

FP001

ST297

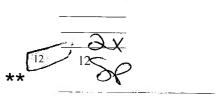
Location	Lo	e Qty
FG		8
103691		8
ST277		405
118709		12
120390		393
	140	Each

140

Each



413.0000



Purchased 49F0432P*

NAS1149C0463R	Purchased
NAS1	149C0463R

Location	Loc Qty		
ST275	636		
121350		636	
-	140	Each	

Loc Qty

827

17

810

828.0000	

Loc Code

Los Coda	
Loc Code	



DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: DISPOSITION Work Order: **AGAINST DEPARTMENT/PROCESS** Rework Skid-tube Crosstube Prod. Eng. Coor. Engineering Part No. Scrap Machining Small Fab Rec/Store/Packaging Quality Thermoforming Use-as-is Finishing Supplier NCR No. Work Order Update Large Fab Composite Other Root Description of work order update Initial Action Sign & Cause Date Step Qty or Non-conformance Chief Eng Description Verification Date QC Inspector Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized **FAULT CATEGORY Landing Gear** Hardware General Bending Passes Below Min Breaking Burrs Maintenance Set-up Centre Not Concentric to O/S Missing Contamination Mislabeled Supplier Cracks Size/Length Cut Too Short Off-Set Temperature/Cure Crushed/Crimp at Bending Spinning Documentation/Data Orientation Misread Weld Inspection Strip in Tube Threading Finish Out of Calibration Wrong Stock Pulled Other Wrong Inspection Incomplete Out of Sequence **Positioned Wrong Drill Holes** Inspection Unqualified **Outside Dimensions** Other Ripples on Inner Bend Misaligned Instructions Incomplete/Unclear Over/Under tolerance Torque Waves in Extrusion Ovalized Jigs/Fixtures/Tooling Part Lost **Turning Sequence** Over/Undersized Kit Incorrect Part Moved Wave/Twist in Tube Too Many Kit Missing Raw Material

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in-lb
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3,43 m	102.2 m-kg
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg

5.0 PARTS LIST

OTV.	QTY	OTY	/ ATV	OTV	QTY	PART NUMBER	DESCRIPTION
QTY -541	-543	QTY -545	/ QTY ≥ -547	QTY -511	-501	PART NUMBER	DESCRIPTION
X X	-543	-545	(-347	-511	-301	D350-607-541	HELI-UTILITY-BASKET
<u> </u>	V		 				HELI-UTILITY-BASKET
	Х			 		D350-607-543	HELI-UTILITY-BASKET
ļ		X	·	 		D350-607-545	HELI-UTILITY-BASKET
		4	X	 x 		D350-607-547	QUICK RELEASE BASKET MOUNTING KIT
1	1	1	/ 1			D350-607-511	CONVERSION KIT
<u> </u>	·····				X	D350-607-501	CONVERSION KIT
1	1	1	/1_		1	-D2690-6	LANYARD
			G.A.C.	4	4	D3910-3	X-TUBE LUG
1	1	1	11		1	D3912-041	EYEBOLT RECEIVER ASSY
			<u> </u>	8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1			1			D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1			~~~	-D4032-041	SHORT BASKET ASSY
			<u> </u>			-D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	11		1	D4085-3	PLACARD-INSTRUCTIONS
1			-			D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1	 		1	D4086-220	PLACARD, MAX LOAD
			11		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	11		1	D4150-041 Z	ATTACHMENT ARM ASSY
1	1	1	2 1		1 .	.D4151-041-	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
			4				
6	6	6	16		6	AN4-13A	BOLT
				16	16	AN4-14A-	BOLT
1	1	1	/1		. 1	AN4C15	BOLT
1	1	1	1			AN310C4	CASTELLATED NUT
1	1	1	71		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	16	16	22	MS21042L4 /	NUT (OR MS21042-4)
1	1	1	2 1		1	MS24665-151 /	COTTER PIN
2	2	2	2 2		2	NAS1515H4L	*WASHER
12	12	12	712	32	44	NAS1149F0432P	.WASHER
3	3	3	[二3		3	NAS1149C0463R	WASHER

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Revision: A

Date: 10.06.28

Work Order ID 85737

June-14-12 1:55:53 PM

85737

Page 1

Item ID:

Revision ID:

D350-607-547

Accept

*N90004010

Setup Start

Item Name: Start Date:

Heli-Utility-Basket

14/06/2012 Start Qty: 1.00

Reg'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: •

Required Date: 28/06/2012

Process Plan: MLJ Date: $\frac{12}{0b}/\frac{4}{12}$ Tooling: Date:

SPC (Y/N):

Start Run

Stop

Sequence ID/ **Work Center ID Draw Nbr**

Operation Description

Revision Nbr

Set Up/ · Run Hours Tool ID

Tool # Plan Code

Accept Qty Qty

Reject Reject

Insp. Number Stamp

D350-607-3

100

DOCUMENT CONTROL

Document Control

Memo

0.00

0.00

Photocopy bluefile & type labels per PPPD350-607-547 CHG00

Cd 12/07/09

140

100

Pick Kit

0.00

140

Packaging Packaging

Memo

0.00

150

QC4-100% Inspect kits for completeness

0.00

150

QC

Memo

Quality Control

0.00